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D3400-041
Job Sheet 209858



Part No: D3400-041

Job Qty: 1 pcs

Part Name: Collective Lock As355



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/20

Job Tracking No:

Due Date: 5/29/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3400 REV.A IPP Rev:A new issue DD 10.04.15 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
120	Small Fab - 1	1 pcs	5/28/20		0.00	1.00	Small Fab - 1			DAS 58 MAY 14 2020 g=80
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
							Small Fab - 8			
							Small Fab - 9			
							Small Fab - Various 1			
150	QC 5	1 pcs	5/28/20		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			
							QC 5 - 82			
154	Large Fab - Welded Assy-2-	1	5/29/20		0.00	0.25	Large Fab - 1 - B4B			

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B4B

pcs

					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
155	Small Fab - 2 - B4B	1	5/29/20	0.00 0.25	Small Fab - 1 - B4B	DAS 58 MAY 19 2020
	pcs				QC 9 - 10	9-89
156	QC 9	1	5/29/20	0.00 0.00	QC 9 - 18	
	pcs				QC 9 - 24	DAS 24
					QC 9 - 43	9-89
					QC 9 - 50	
					QC 9 - 9	
160	Packaging 3-1 - Stock - B4B	1	5/29/20	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	✓ DAS 80
					Packaging 3 - 4 - B4B	9-89
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	MAY 21 2020
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
170	QC 21 - SA	1	5/29/20	0.00 0.00	QC 21 - SA - 21	DAS 21 MAY 21 2020
	pcs				QC 21 - SA - 70	5-88

Part Op 120 - 1- Press fit dowel pin in D3400-5 2-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock Descriptions: barrel. Discard the rest. 3-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 4-Assemble D3400-053 as per Dwg D3400. Apply a drop of permanent locktite 262 to the threads A/R Locktite 262 Batch: _____ 5-Assemble D3400-051 as per Dwg

150 - (QC5- Inspect part completeness to step on W/O)

154 - Tack weld lock shaft as per Dwg D3400 A/R SS Rod Batch: M139023

155 - Change out the body, spacer and lock

156 - QC9- Inspect visual per QSI004- Fusion Welds

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
238-028	3/16" Dowel Pin .5" long	2 Ea (2 ea)	120-Small Fab - 1	
5/16WC	Washer	2 Ea (2 ea)	120-Small Fab - 1	
D3369-5	Spacer	1 pcs (1 ea)	120-Small Fab - 1	
D3372-5	Cam Lock Shaft	1 pcs (1 ea)	120-Small Fab - 1	
D3373-1	Cam Lock	1 pcs (1 ea)	120-Small Fab - 1	
D3384-043	Cyclic Sock Assembly	1 pcs (1 ea)	120-Small Fab - 1	
D3400-1	Main Body	1 pcs (1 ea)	120-Small Fab - 1	
D3400-3	Guide	2 pcs (2 ea)	120-Small Fab - 1	
D3400-5	Slider Body	1 pcs (1 ea)	120-Small Fab - 1	
HX-81	1/4"-20 SHCS 3/8" long	1 Ea (1 ea)	120-Small Fab - 1	
NAS1149F0463P	Washer (AN960-416)	2 Ea (2 ea)	120-Small Fab - 1	
5/16WC	Washer	2 Ea (2 ea)	155-Small Fab - 2 - B4B	S243414
D3369-5	Spacer	1 pcs (1 ea)	155-Small Fab - 2 - B4B	S268793
D3372-5	Cam Lock Shaft	1 pcs (1 ea)	155-Small Fab - 2 - B4B	B123560
D3373-1	Cam Lock	1 pcs (1 ea)	155-Small Fab - 2 - B4B	S148674
D3400-1	Main Body	1 pcs (1 ea)	155-Small Fab - 2 - B4B	F 579941
D3400-3	Guide	2 pcs (2 ea)	155-Small Fab - 2 - B4B	S278614

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	238-028	2	81	0
	5/16WC	2	369	0
	D3369-5	1	5	0
	D3372-5	1	3	0
	D3373-1	1	13	0
	D3384-043	1	3	0
	D3400-1	1	5	0
	D3400-3	2	0	0
	D3400-5	1	5	0
	HX-81	1	22	0
	NAS1149F0463P	2	183	0
	5/16WC	2	369	0
155-Small Fab - 2 - B4B	D3369-5	1	5	0
	D3372-5	1	3	0
	D3373-1	1	13	0
	D3400-1	1	5	0
	D3400-3	2	0	0

Part Specifications

Specifications could not be found.

Descriptions: barrel. Discard the rest. 3-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 4-Assemble D3400-053 as per Dwg D3400. Apply a drop of permanent locktite 262 to the threads A/R Locktite 262 Batch: _____ 5-Assemble D3400-051 as per Dwg

150 - (QC5- Inspect part completeness to step on W/O)

154 - Tack weld lock shaft as per Dwg D3400 A/R SS Rod Batch: M13902 3

156 - QC9- Inspect visual per QSI004- Fusion Welds

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
238-028	3/16" Dowel Pin .5" long	2 Ea (2 ea)	120-Small Fab - 1	S226094
5/16WC	Washer	2 Ea (2 ea)	120-Small Fab - 1	S043414
D3369-5	Spacer	1 pcs (1 ea)	120-Small Fab - 1	S268793
D3372-5	Cam Lock Shaft	1 pcs (1 ea)	120-Small Fab - 1	F123362
D3373-1	Cam Lock	1 pcs (1 ea)	120-Small Fab - 1	S204947
D3384-043	Cyclic Sock Assembly	1 pcs (1 ea)	120-Small Fab - 1	F163418
D3400-1	Main Body	1 pcs (1 ea)	120-Small Fab - 1	S082037
D3400-3	Guide	2 pcs (2 ea)	120-Small Fab - 1	S277618
D3400-5	Slider Body	1 pcs (1 ea)	120-Small Fab - 1	S086037
HX-81	1/4"-20 SHCS 3/8" long	1 Ea (1 ea)	120-Small Fab - 1	S012160
NAS1149F0463P	Washer (AN960-416)	2 Ea (2 ea)	120-Small Fab - 1	S247854

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Small Fab - 1	238-028	2	87	0
	5/16WC	2	371	0
	D3369-5	1	6	0
	D3372-5	1	4	0
	D3373-1	1	14	0
	D3384-043	1	4	0
	D3400-1	1	6	0
	D3400-3	2	0	0
	D3400-5	1	6	0
	HX-81	1	25	0
	NAS1149F0463P	2	232	0

Part Specifications

Specifications could not be found.

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Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

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Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Rec/Store/Packaging ☐ Supplier ☐ Finishing ☐ Quality ☐																															
Date :	Sequence #:	QTY Affected :		MRB (QSI042)																															
Description Work Order Deviation				Disposition																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>Contamination</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr><tr><td>Bending</td><td>Misaligned/off center</td><td>Folio/Program</td><td>Outside Tolerance</td></tr><tr><td>Crushing</td><td>BOM/Route</td><td>Grain Direction</td><td>Drawing</td></tr><tr><td>Cracks</td><td>Broken/Damage/Defect</td><td>Weld</td><td>Finish</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>Incomplete/Unclear Instructions</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr><tr><td>Marks/Chatter</td><td>Drill Holes</td><td>Out of Sequence</td><td>Misread</td></tr><tr><td>Mislabeled</td><td>Fit/Function</td><td>Off-set/Set-up</td><td></td></tr></table> Other/Details:						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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